

Work Order ID 55388

January 15, 2010 9:07:24 AM



Page 1

Item ID: D4048-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 1/15/10 Start Qty: 4.00

Required Date: 1/22/10 Req'd Qty: 4.00

Cust Item ID:

Customer:

PRELIMINARY ISSUE



Reference:

26-1
10.01.15

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4048

PA1

PA3

DA 10/04/22

100

0.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

0.00

Bandsaw

Memo

Jeaspa Bandsaw

CUT BLANK 4.30" LONG

H.A

10/01/13

110

0.00



HAAS 1

Memo

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA893

DWG REV:

FOLIO REV:

PA 1
PA 1

0.00

H.A 10/01/13

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55388

January 15, 2010 9:07:24 AM



Page 2

Item ID: D4048-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 1/15/10

Start Qty: 4.00



Cust Item ID:

Required Date: 1/22/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

H.A 10/01/18

2

Ø

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

⇒ 51010120

x2

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

⇒ 1010121

x2 0

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries

Work Order ID 55388



January 15, 2010 9:07:25 AM






Page 3

Item ID: D4048-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Mounting Lug
Start Date: 1/15/10 Start Qty: 4.00  Cust Item ID:
Required Date: 1/22/10 Req'd Qty: 4.00  Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M113170 Memo START: 3:30pm Temp: 320°F Fin: 4:00pm	0.00 0.00	= 241	10-01-21		(X2)	Ø		
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BK	10-01-21		(2)	Ø		
170  Packaging Packaging	Identify as per dwg & Stock Location: 468 Memo	0.00 0.00				10-1-22	(2)	SP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55388

January 15, 2010 9:07:25 AM



Page 4

Item ID:	D4048-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Mounting Lug					
Start Date:	1/15/10	Start Qty:	4.00		Cust Item ID:	
Required Date:	1/22/10	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Prototype test
10.01.30*

*MF
10-1-25*

POSITIVE RECALL
EFFECTIVE 10/1/10 AUTH W
RELEASED DATE

Picklist Print

January 15, 2010 9:07:23 AM

Page 1

Work Order ID: 55388

Parent Item: D4048-1

Parent Item Name: Mounting Lug

Comments: IPP REV:A NEW ISSUE JLM 10-01-07 VERIFIED BY:DD

Start Date: 1/15/10

Required Date: 1/22/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased	No			100	f	16.8667	1.5074			



6061-T6 Bar 3.00 x 1.50



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

16.8667

109058

16.8667

7243 ft M.A 10/01/18

memo 8740
109058
28/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 55388
Description: MOUNTING LUG		Part Number: D4048-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

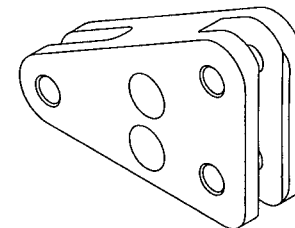
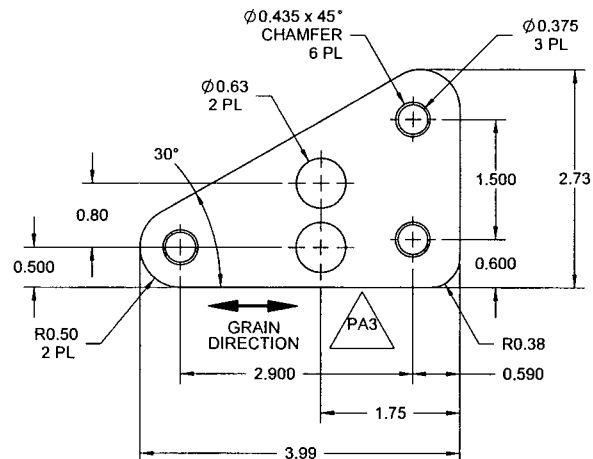
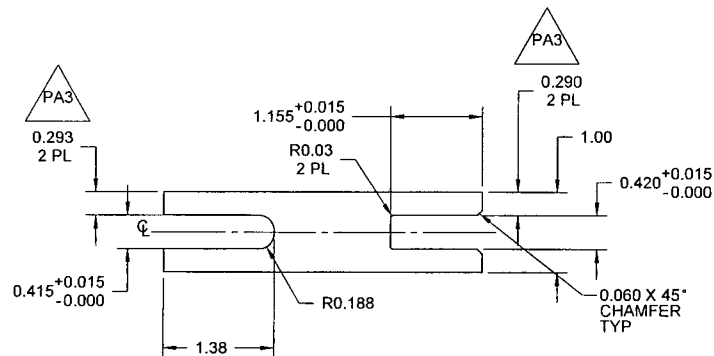
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.155	+0.05 / -0.000	1.160	✓			
0.415	+0.05 / -0.000	0.417	✓			
1.360	+/- .030	1.380	✓			
R 0.188	+/- .010	R0.188	✓			
0.060x45°	+/- .010 x 1/2°	0.061x45°	✓			
0.420	+0.05 / -0.000	0.420	✓			
1.00	+/- .030	1.001	✓			
R0.50	+/- .030	R0.500	✓			
0.500	+/- .010	0.499	✓			
0.80	+/- .030	0.800	✓			
30°	+/- 1/2°	30°	✓			
Ø 0.63	+0.008 / -0.001	Ø0.629	✓			
Ø 0.375	+0.006 / -0.001	Ø0.381	✓			
2.73	+/- .030	2.730	✓			
1.500	+/- .010	1.499	✓			
0.600	+/- .010	0.600	✓			
R0.38	+/- .030	R0.380	✓			
0.590	+/- .010	0.590	✓			
1.75	+/- .030	1.748	✓			
3.99	+/- .030	3.992	✓			
2.900	+/- .010	2.900	✓			
1.740	+/- .010	1.744	✓			
2.900	+/- .010	2.906	✓			

Measured by: H.A.
Date: 10/01/18

Audited by: E
Date: 10/01/20

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



WLO 55388

D4048-1 MOUNTING LUG



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

PRELIMINARY ISSUE

RF 10.01.18

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4048	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
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